

Amendments to the Claims

This listing of claims replaces all prior versions, and listings, of claims in the application.

Listing of Claims

Claim 1. (Currently amended) [[::]] ~~Process A process~~ for the automatic control of the thickness of an extruded film—~~that comprises of the following features~~ film, comprising:

~~Measurement of the measuring a thickness value profile of the film just extruded (8) film with the help of a thickness-measuring probe (12) that is moved along the a surface of the film in a direction (x) that is substantially perpendicular (x) to the a conveying direction (z) of the extruded film, (8). The the thickness-measuring probe records recording for each measuring cycle (MZ)—a the thickness value profile (P) of the film (8) at least across parts of the an expansion area of the film (8) in the direction (x) perpendicular (x) to it's the conveying direction (z) [[,]];~~

~~Transmitting transmitting the measured values to a control unit (14, 15, 17)[[,]];~~

~~Storage of storing the measured values underlying the thickness profiles in a storage unit (14)[[,]];~~

~~Provision of determining statistical values of the film thickness (5) using with a computer (14), whereby the computer~~

(14) takes into account accounting for the measured values or information derived therefrom using a definite fixed number (N) of the measuring cycles (M_Z) and [[,]] if necessary, provides providing measured values from recent and older previous measuring cycles with different weighting factors, the measured values obtained during a predetermined time-frame at a start of the extrusion process being more heavily weighted by the computer than the measured values obtained during a normal operation subsequent to the predetermined start time-frame;

Determination of the determining deviations in the statistical values of the film thickness (5) from a target value[[,]]; and

Generating generating control commands to a device for controlling the film thickness (5)

~~characterized in that~~

while providing the statistical values in relation to the older measured values, the latest measured value(s) during a predetermined time frame at the start of the extrusion process are more heavily weighted by the computer (14) than those measured during the normal operation.

Claim 2. (Currently amended) [[:]] Process The process pursuant to claim 1 ~~characterized in that~~ wherein the computer (14) determines the statistical values by taking into account accounting for the measured values or the information derived

therefrom using a smaller number (N) of the measuring cycles (Mz) during a the predetermined time-frame at the start of the extrusion process than the a number of the measuring cycles used during the normal operation.

Claim 3. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 1 ~~characterized in that~~ wherein the computer (14) determines the statistical values during a the predetermined time-frame at the start of the extrusion process wherein and at least one ~~older~~ previously measured value is provided with a smaller weighting factor than the weighing factor used during the normal operation.

Claim 4. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 1 ~~characterized in that~~ wherein the computer (14) determines the statistical values during a the predetermined time-frame at the start of the extrusion process wherein and at least one ~~recent~~ recently measured value is provided with a larger weighting factor than the weighting factor used during the normal operation.

Claim 5. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 2 ~~characterized in that~~ wherein at least one of the number (N) of the measuring cycles (Mz) and/or and the weighting factors

after the start of the extrusion process are made to approximate in steps at least one of the number $\{N\}$ of the measuring cycles $\{MZ\}$ used in the normal operation and/or and the weighting factors used in the normal operation.

Claim 6. (Currently amended) [[:]] Device A device for the automatic control of the thickness of the an extruded film, $\{S\}$ having the following features comprising:

a thickness-measuring probe $\{12\}$ for measuring the that measures a thickness value profile of the film just extruded $\{S\}$ film that is moved along the a surface of the film $\{S\}$ in a direction $\{x\}$ that is substantially perpendicular $\{x\}$ to the a conveying direction $\{z\}$ of the extruded film, $\{S\}$. The the thickness measuring probe $\{12\}$ records recording for each measuring cycle $\{MZ\}$ a the thickness value profile $\{P\}$ of the film $\{S\}$ at least across parts of the an expansion area of the film $\{S\}$ in the direction $\{x\}$ perpendicular $\{x\}$ to it's the conveying direction $\{z\}$ [[,]];

Transmitting a device that transmits the measured values to a control unit $\{14, 15, 17\}$ [[,]];

A a storage unit $\{14\}$ for recording that records the measured values and the information derived therefrom [[,]];

A a computer $\{14\}$ for providing that determines statistical values of the film thickness $\{S\}$ taking into account by accounting for the measured values or the information derived

therefrom using a definite fixed number (N) of the measuring cycles (MZ) and using which (14), if necessary, providing measured values from recent and older previous measuring cycles can be provided with different weighting factors, the measured values obtained during a predetermined time-frame at a start of the extrusion process being more heavily weighted by the computer than the measured values obtained during a normal operation subsequent to the predetermined start time-frame, and whereby even the determines deviations in the statistical values of the film thickness (5) from a target value can be determined using the computer (14) [[,]], and

A a device (17) for generating that generates control commands to a device for controlling that controls the film thickness (5)

characterized in that

while providing the statistical values in relation to the older measured values the latest measured value(s) from a predetermined time frame at the start of the extrusion are heavily weighted using the computer (14) than during the normal operation.

Claim 7. (Currently amended) [:] Process The process pursuant to claim 2 characterized in that wherein the computer (14) determines the statistical values during a the predetermined time-frame at the start of the extrusion process wherein and at least one older previously measured value is provided with a

smaller weighting factor than the weighing factor used during the normal operation.

Claim 8. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 2 ~~characterized in that~~ wherein the computer (14) determines the statistical values during a the predetermined time-frame at the start of the extrusion process wherein and at least one ~~recent~~ recently measured value is provided with a larger weighting factor than the weighting factor used during the normal operation.

Claim 9. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 3 ~~characterized in that~~ wherein the computer (14) determines the statistical values during a the predetermined time-frame at the start of the extrusion process wherein and at least one ~~recent~~ recently measured value is provided with a larger weighting factor than the weighting factor used during the normal operation.

Claim 10. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 3 ~~characterized in that~~ wherein at least one of the number ~~(N)~~ of the measuring cycles ~~(MZ)~~ and/or and the weighting factors after the start of the extrusion process are made to approximate in steps the number ~~(N)~~ of the measuring cycles ~~(MZ)~~

used in at least one of the normal operation and/or and the weighting factors used in the normal operation.

Claim 11. (Currently amended) [:] Process The process pursuant to claim 4 ~~characterized in that~~ wherein at least one of the number $\{N\}$ of the measuring cycles $\{MZ\}$ and/or and the weighting factors after the start of the extrusion process are made to approximate in steps at least one of the number $\{N\}$ of the measuring cycles $\{MZ\}$ used in the normal operation and/or and the weighting factors used in the normal operation.